

Date: Tuesday, 5/16/2006 10:40:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 27143	
Estimate Number : 11376	
P.O. Number : N/A	Part Number : D33872
This Issue : 5/16/2006 S.O. No. : N/A	Drawing Number : D3387 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 27105	Material : N/A
Written By : <i>See 1st comment below</i>	Due Date : 5/30/2006
Checked & Approved By : <i>06.05.16</i>	Qty: 10 Um: Each
Comment : Est:A 05.06.10 New Issue KJ/JLM Est:B 06.03.22 Split c'sink op. EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5680 f(s)/Unit Total: 15.6797 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6/T651 (QQ-A-200/8)
 (M6061T6B0.500x06.000)
 Identify for D3387-2
 Batch: *M100817*

ml 06/05/19 16

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 6.000" x 0.500" x 17.800" long

ml 06/05/19 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA512 and Dwg D3387
 Identify as D3387-2
 Tumble and Deburr NO sharp edges

J.F. 06/05/20 10

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 C'sink Ø0.375" as per Dwg D3387.

ml 06/05/24 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *DS* Date: 04/05/25

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 27143

Part Number: D33872

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/05/25

10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/05/25

10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA28*

PE 06.05.25

10

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PD 06/05/25

(10)

Job Completion



C 206/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27143
Description: Arm		Part Number:	D3387-2
Inspection Dwg: D3387		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.502	—			
7.577	+/-0.010	7.578	—			
R0.030	+/-0.010	R0.030	—			
Ø0.191	+0.005/-0.000	Ø0.192	—			
1.700	+/-0.010	1.703	—			
0.188	+/-0.010	0.190	—			
11.405	+/-0.010	11.405	—			
Ø0.507	+0.000/-0.001	Ø0.507	—			
2.033	+/-0.005	2.033	—			
R0.300	+/-0.010	R0.300	—			
1.000	+/-0.005	1.000	—			
2.000	+/-0.010	2.003	—			
1.347	+/-0.005	1.347	—			
0.250	+/-0.010	0.245	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.122	—			
R0.032	+/-0.010	R0.032	—			
Ø0.375 x100°	+/-0.010	Ø0.375x100°	—			
0.500	+/-0.010	0.493	—			
0.300	+/-0.010	0.297	—			

Measured by:	JML	Audited by:	J.F.	Prototype Approval:	N/A
Date:	06/05/19	Date:	06/05/20	Date:	N/A

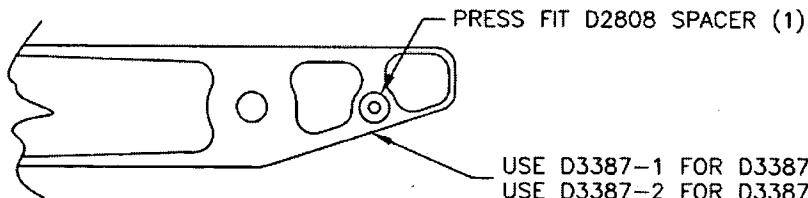
Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	JML

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.01.18	DRAWING NO. D3387	REV. A
	TITLE ARM	SHEET 1 OF 1
A	05.01.18	NEW ISSUE
		SCALE 1:3

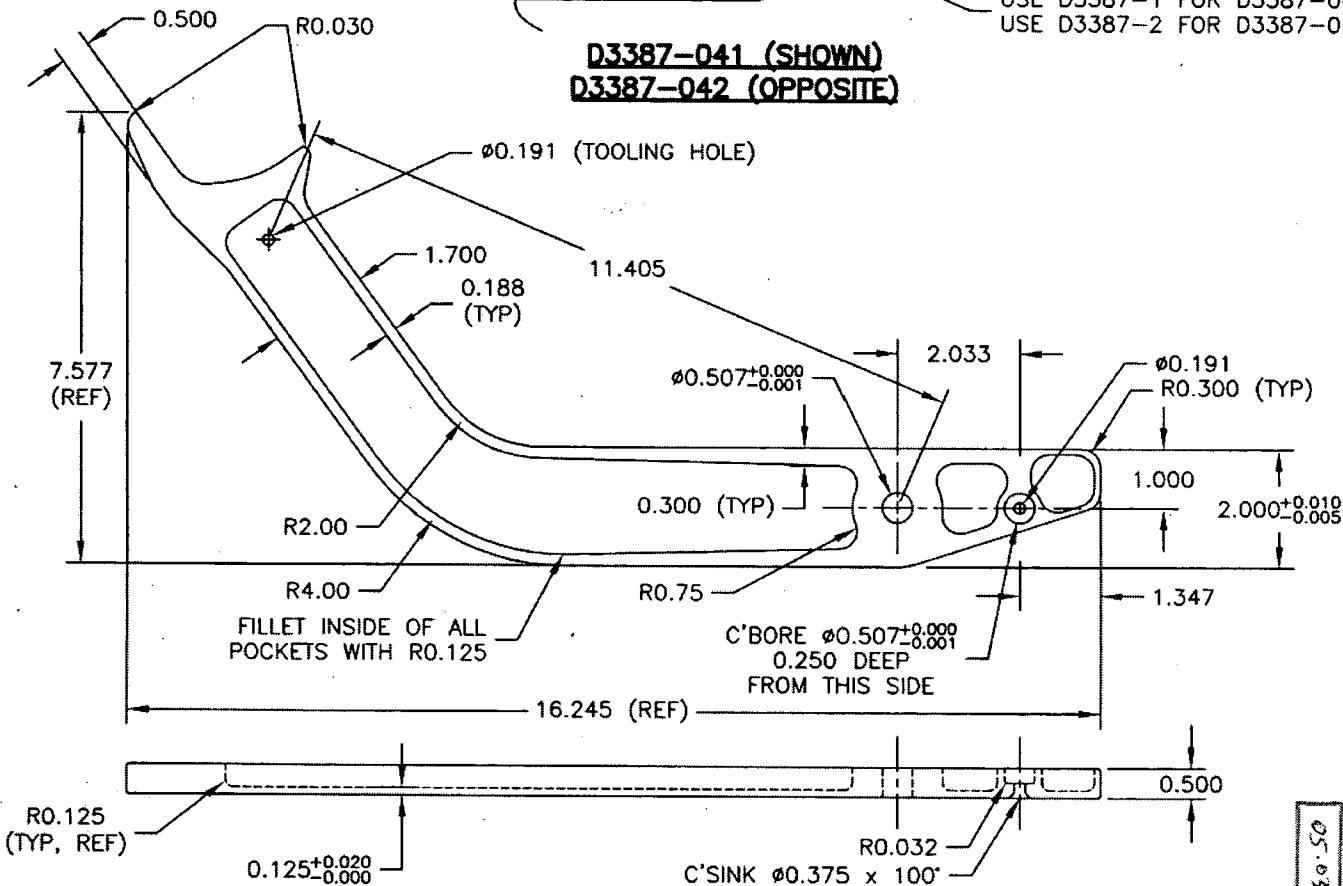
RELEASED

05.03.11



USE D3387-1 FOR D3387-041
USE D3387-2 FOR D3387-042

D3387-041 (SHOWN)
D3387-042 (OPPOSITE)



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

1. MACHINE PER DRAWING FILE "D3387-A.DWG"
2. MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK (REF DART SPEC. M6061T6B0.500)
3. DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5. ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 27143

